

Work Order ID 55903

February 04, 2010 10:06:23 AM



Page 1

Item ID: D117-762-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube

Stop



Start Date: 02/04/2010 Start Qty: 2.00



Cust Item ID:

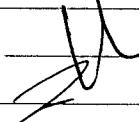
Required Date: 02/11/2010 Req'd Qty: 2.00



Customer:

Reference: NCR10-011 Re-work

Approvals: Process Plan:

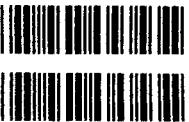


Date: 10-02-04

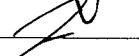
Tooling:

Date:

Run Start



QC:



Date: 10-02-04

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
N/A	Rev A

100



QC

Quality Control

Memo

0.00

(2x)

Pull from stock per NCR10-011
 1x B54149
 1x B54150
 and have re-worked.

=> m.k 10/02/16

110



Assemble as per dwg

0.00

HandFinish

Hand Finishing

Memo

0.00

-Remove the D3508-9 wearplate & re-work per attached NCR w/o sheet.
 **Ensure the slot is made square: 0.300" x 0.360"(maximum) towards the centerline on the most forward holes only.

>DP

10-2-11

-Debur the wearplate & touch up grey.

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Stop



Start Date: 02/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 02/11/2010 Req'd Qty: 2.00



Customer:

Reference: NCR10-011 Re-work

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Soler 16

(10)

130



HandFinish

Hand Finishing

Assemble as per dwg

0.00

=> M-h 10/02/16

(2X)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Soler 16

(x2)

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Item ID: D117-762-011

Accept



Setup

Start



Revision ID:

Item Name: Skidtube

Stop



Start Date: 02/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 02/11/2010 Req'd Qty: 2.00



Customer:

Reference: NCR10-011 Re-work

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150



Identify as per dwg & Stock Location:

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Nov A

0.00

Packaging

Packaging

Memo

0.00

Ensure the correct tube goes back into the correctly identified box.

Also ensure the corresponding kit & paperwork is included.

Re-stock using the original batch #

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Add a copy of this w/o to the original w/o's as a reference.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See NCR 10-011

Part No: D117-762-041 PAR #: 1 Fault Category: Prod. Skidtubes NCR: Yes No DQA: Date: 10-02-04

Resolution: re-work Disposition: re-work QA: N/C Closed: Date: _____

NCR: 10-011		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-02-04	250	Upon assembly of the D3508-9 wear plate, it was noticed that the holes in the tube were too narrow and causing the wear plate to lift in the center when tightened.	Initial CDSI 042	- Drill/ig fuel hole angle slightly changed (came in) with use, due to mild O.D. crushing on the tube from bending. D78974 is Reworked.	See NCR 10-011	10-02-04	CDSI 042	CDSI 042
		R.C: Tooling.	CP 10-02-04 CDSI 042	- On the 2 most fuel holes on the D3508-9 wearplate, slot the holes, square, to max 0.060" (or as necessary), to allow the bolts to tighten	S 10-02-10 10-02-11C		CP 10-02-07 CDSI 042	10-02-04
			CP 10-02-04 CDSI 042	- Without any bending upon the wear plate, 0.300 x 0.360" marking. & open/slot, square to 0.060" maximum towards center line. CDSI 042 - NON STRUCTURAL, ACCEPTABLE	S 10-02-11C 10-02-11E		CP 10-02-04 CDSI 042	10-02-04

NOTE: Date & initial all entries